

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: xx.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019681**Date Inspected:** 27-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** SHANGHAI CHINA**CWI Name:** Mr. Li Ming Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG TRIAL ASSEMBLY & bay 14**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Raghavendra Reddy was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

OBG Trial assembly area:

HEAT STRAIGHTENING

This QA Inspector observed the following work in progress:

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as Floor beam at panel point 112 cross beam side. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Wang Zhu was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) 9784.

Bay 14:-

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3020D-052(14W, Bottom plate and floor beam), And Critical Welding Repair Report (CWR) B-CWR2734 Rev.1, and Welder is identified as 066038; ZPMC Quality

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Control (QC) is identified as Mr. Li Ming Yang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint SEG3020E-056(14W, Bottom plate and floor beam), And Critical Welding Repair Report (CWR) B-CWR2734 Rev.1, and Welder is identified as 066398; ZPMC Quality Control (QC) is identified as Mr. Li Ming Yang. The welding variables appeared to comply with the Applicable WPS-345-SMAW-2G (2F)-FCM-Repair-1.

Shielded Metal Arc (SMAW) welding of Weld Joint DP3148-001-247(13BW, PP123 Deck panel diaphragm), And Welder is identified as 037840; ZPMC Quality Control (QC) is identified as Mr. Shen Jian. The welding variables appeared to comply with the Applicable WPS-B-P-2213-U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Tharikoppada,Reddy	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
